



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5951

Job Sheet 193240



Part No: D5951

Job Qty: 5 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:E Re-Format 05-11-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	5 pcs	4/26/19		0.54	15.15	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/04/19
							HAAS - 4		
110	QC 2	5 pcs	4/26/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/04/19
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Container No: S170982



Part: D5951

Job No: 193240

Serial No/Batch: S170982

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/09/19

120 QC 8	5 pcs	4/26/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Handfinish - 1-1 Chemical-B4B	5 pcs	4/26/19	0.00 0.38	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	

Amor 19/04/11

D.R 19/04/11

				B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
140	Powdercoat - 1 White GI(A)- B4B	5 pcs	4/26/19	0.00	0.27	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
150	QC 3	5 pcs	4/26/19	0.00	0.00	QC 3 - 10
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
160	Packaging 3-1 - Stock - B4B	5 pcs	4/26/19	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		

1151749.
START: 10:55 A.T. 328 FINISH: 11:25
B4B 19-04-15

DAS
APR 15 2019 40
9-89

				Packaging 3 - 27 - B4B	54399	APR 16 2019
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
170 QC 21 - SA	5	4/26/19	0.00 0.00	QC 21 - SA - 21		
	pcs			QC 21 - SA - 70	DAG	
				QC 21 - SA - 53	21	APR 16 2019

Part Op **100** - (HAAS CNC Vertical Machine), 1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway
 Descriptions: 3-Debur & Tumble
120 - (QC8- Inspect parts - second check)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____
150 - (QC3- Inspect Part Finish)
160 - (Identify as per dwg & Stock Location: _____)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-013	Saddle Billet	5 pcs (1 ea)	100-HAAS 4 Axis	1x 5082697 4x 5111634

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-013	5	11	0

Part Specifications
Specifications could not be found.

DART AEROSPACE LTD		Work Order: 193740
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.502		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		7.998	7.998	7.998	7.998		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	0.312	0.312	0.312		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.500	0.500	0.499	0.501		
T	1.375	1.395		1.375	1.375	1.375	1.375		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DAS Date: 57 19/04/10 9-89	Audited by: <i>mm</i> Date: 19/04/10
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Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	193240
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Inspection Dwg: D5951	Rev: B	Page 1 of 1	

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D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		0.316					
H	1.522	1.532		1.527					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.315	0.322		0.316					
L	0.495	0.505		0.500					
M	0.490	0.510		0.502					
N	1.615	1.635		1.625					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.312					
R	0.760	0.765		0.760					
S	0.490	0.510		0.500					
T	1.375	1.395		1.375					
U	2.000	2.020		2.000					
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DAS
Date:	57 19/04/10
	9-89

Audited by:	MMML
Date:	19/04/11

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